

# Work Order ID 61482

Thursday, August 26, 2010 2:42:05 PM



Page 1

Item ID: D3183-044

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 8/26/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blanks: (1.500" x 2.250") 5.500" long

SL 10/09/19

8

1

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3183-4 as per Folio FA322 and Dwg D3183 Identify as D3183-4  
4-2-Deburr 3-Scribe batch number

SL/mtf  
10/09/20

PTO

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mtf 10/09/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3183-044 PAR #: \_\_\_\_\_ Fault Category: machining NCR: Yes No DQA: ✓ Date: 10/09/22  
 Resolution: Scrap Disposition: scrap QA: N/C Closed: ✓ Date: 10/09/24

NCR: <u>61482</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/09/20</u>	<u>110</u>	part flew out of vice while machining, I put it back but the spigot came out off center	<u>✓</u> <u>10/09/22</u>	-scrap + replace Qty: 1 Batch # <u>M113568</u>	<u>✓</u> <u>10/09/20</u>	<u>✓</u> <u>10/09/23</u>	<u>✓</u> <u>10/09/22</u>	<u>✓</u> <u>10/09/22</u>
		R.C. bad tooling/process not very much material holding in the vice	<u>✓</u> <u>10/09/22</u>					

NOTE: Date & initial all entries

# Work Order ID 61482

Thursday, August 26, 2010 2:42:05 PM



Page 2

Item ID:	D3183-044	Accept		Setup	Start	
Revision ID:						
Item Name:	Bracket Assembly				Stop	
Start Date:	8/26/2010	Start Qty:	8.00			
Required Date:	9/6/2010	Req'd Qty:	8.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				8	1		
Quality Control									

140	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble D3183-043 as per Dwg D3183.								

150	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*SP 10/09/23*

*EP 10/09/22 (8)*

*S 10/09/23*

*(XS)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61482**

Thursday, August 26, 2010 2:42:05 PM



Page 3

Item ID: D3183-044

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 8/26/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 23e

0.00



Packaging

Memo

0.00

Packaging

10/9/23 sf 80

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/24 [Signature]  
MF  
10-9-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, August 26, 2010 2:42:09 PM

Page 1

Work Order ID: 61482

Parent Item: D3183-044

Parent Item Name: Bracket Assembly




Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:Pick:A 04.02.18 New issue KJ/DS  
IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-045  Bearing Assembly		Manufactured	No			100	Each	25.0000	2	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST236		25							
				60152		5							
				60502		20							
D3121-21  Bolt		Manufactured	No			140	Each	43.0000	2	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235		43							
				57376		1							
				59044		2							
				60493		40							
M174B1.500X02.250  17-4 SS Bar 1.50 X2.250		Purchased	No			140	f	18.7107	0.4583	3.859368			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT031		18.71066							
				108309		1							
				113568		17.71066							

*Handwritten notes:*  
 1/06/19  
 B 61671 (4x)  
 B61642 (2x)  
 E 510/09/22  
 E 510/09/22  
 B61648 (6x)  
 B61839 (10x)

*Handwritten mark:* A

*Handwritten number:* 39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	612182
<b>Description:</b> Bracket		<b>Part Number:</b>	D3183-4
<b>Inspection Dwg:</b> D3183	<b>Rev:</b> C1	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.190	✓		R-g	N/A
R0.063	+/-0.010	R.063	✓		R-g	N/A
<del>0.182</del> 0.188	+/-0.010	<del>0.182</del>	✓		Vern	ML-7
0.070	+/-0.010	0.070	✓		Vern	ML-7
0.100	+/-0.010	0.104	✓		Vern	ML-7
Ø0.201 x 0.100	+/-0.010	Ø.201 x .102	✓		Vern	ML-7
<del>0.182</del> 0.183	+/-0.010	<del>0.182</del>	✓		Vern	ML-7
5.32	+/-0.030	5.314	✓		Vern	ML-7
5.036	+/-0.010	5.031	✓		H-g	31006
2.120	+/-0.010	2.120	✓		H-g	31006
1.290	+/-0.010	1.288	✓		Vern	ML-7
0.365	+/-0.010	0.364	✓		Vern	ML-7
0.218	+/-0.010	0.212	✓		Vern	ML-7
1.030	+/-0.010	1.031	✓		Vern	ML-7
1.90	+/-0.030	1.888	✓		Vern	ML-7
1.012	+/-0.010	1.004	✓		Vern	ML-7
Ø0.201 x 0.100	+/-0.010	Ø.201 x .103	✓		Vern	ML-7
0.786	+/-0.010	0.778	✓		H-g	31006
Ø0.392	+0.002/-0.000	Ø.3931	✓		Micro	ML-8
R0.19	+/-0.030	R.190	✓		R-g	MA
3.954	+/-0.010	3.955	✓		H-g	31006
0.162	+/-0.010	0.158	✓		Vern	ML-7
R0.19	+/-0.030	R.090	✓		Radius-g	N/A
R0.25	+/-0.030	R.250	✓		Radius-g	N/A
4.26	+/-0.030	4.262	✓		Vern	ML-7
2.800	+/-0.030	2.830	✓		Vern	ML-7
Calculated dimension						
0.162	+/-0.010	0.153	✓		Vern	ML-7
0.615	+/-0.010	0.617	✓		Vern	ML-7
0.435	+/-0.010	0.434	✓		Vern	ML-7
0.200	+/-0.010	0.200	✓		Vern	ML-7
0.381	+/-0.010	0.390	✓		Vern	ML-7
0.032	+/-0.010	0.032	✓		Depth-g	ML-05

<b>Measured by:</b> <i>anf</i>	<b>Audited by:</b> <i>SP</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/09/21	<b>Date:</b> 6/09/23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

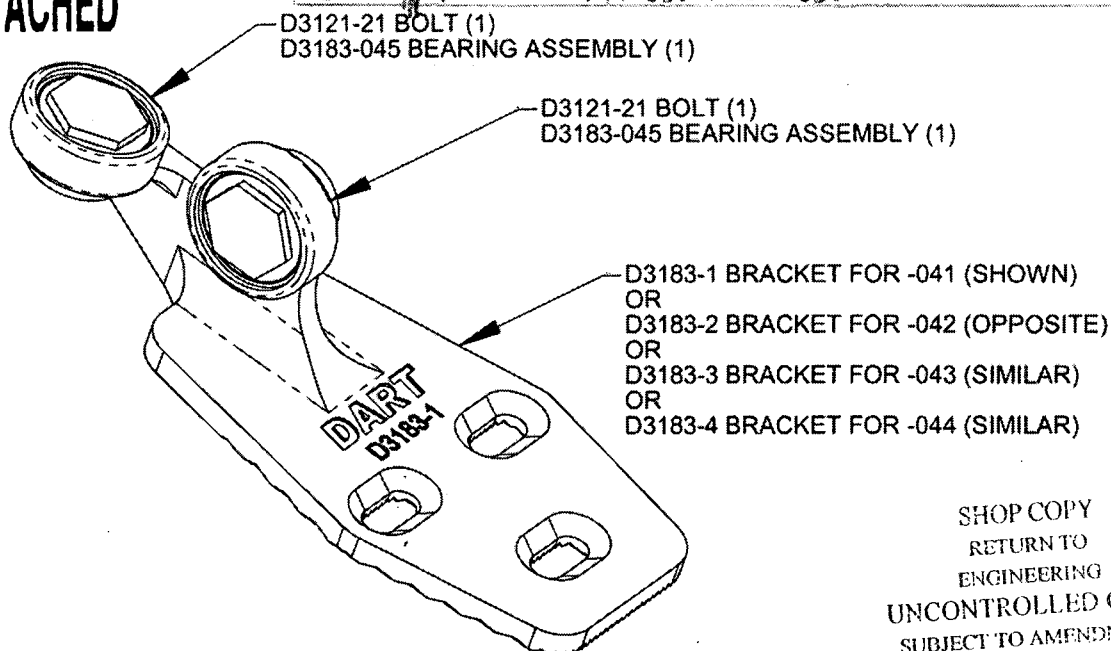
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



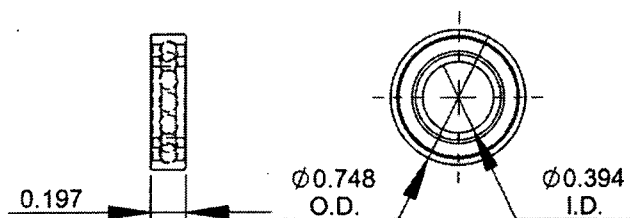
DESIGN #	DRAWN BY CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3183</b>	REV. C SHEET 1 OF 4
DATE <b>04.02.17</b>	TITLE <b>BRACKET ASSEMBLY</b>		SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	04.11.09	0.830 WAS 0.850	

**RELEASED**  
04.03.01  
**DEO ATTACHED**



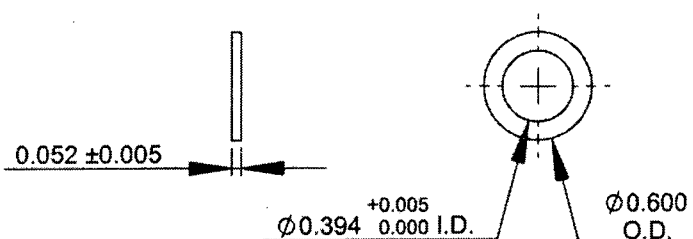
**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 61182  
2810-826



**D3183-5 BEARING:**  
**SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



**D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

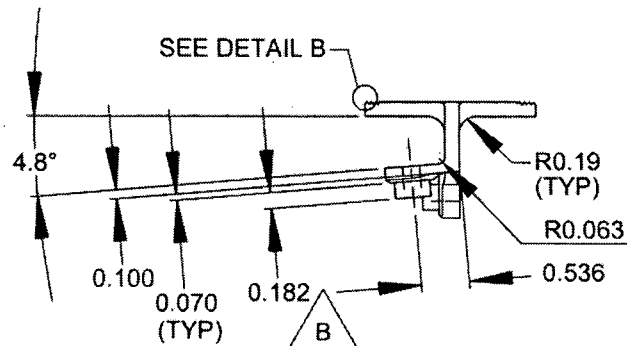
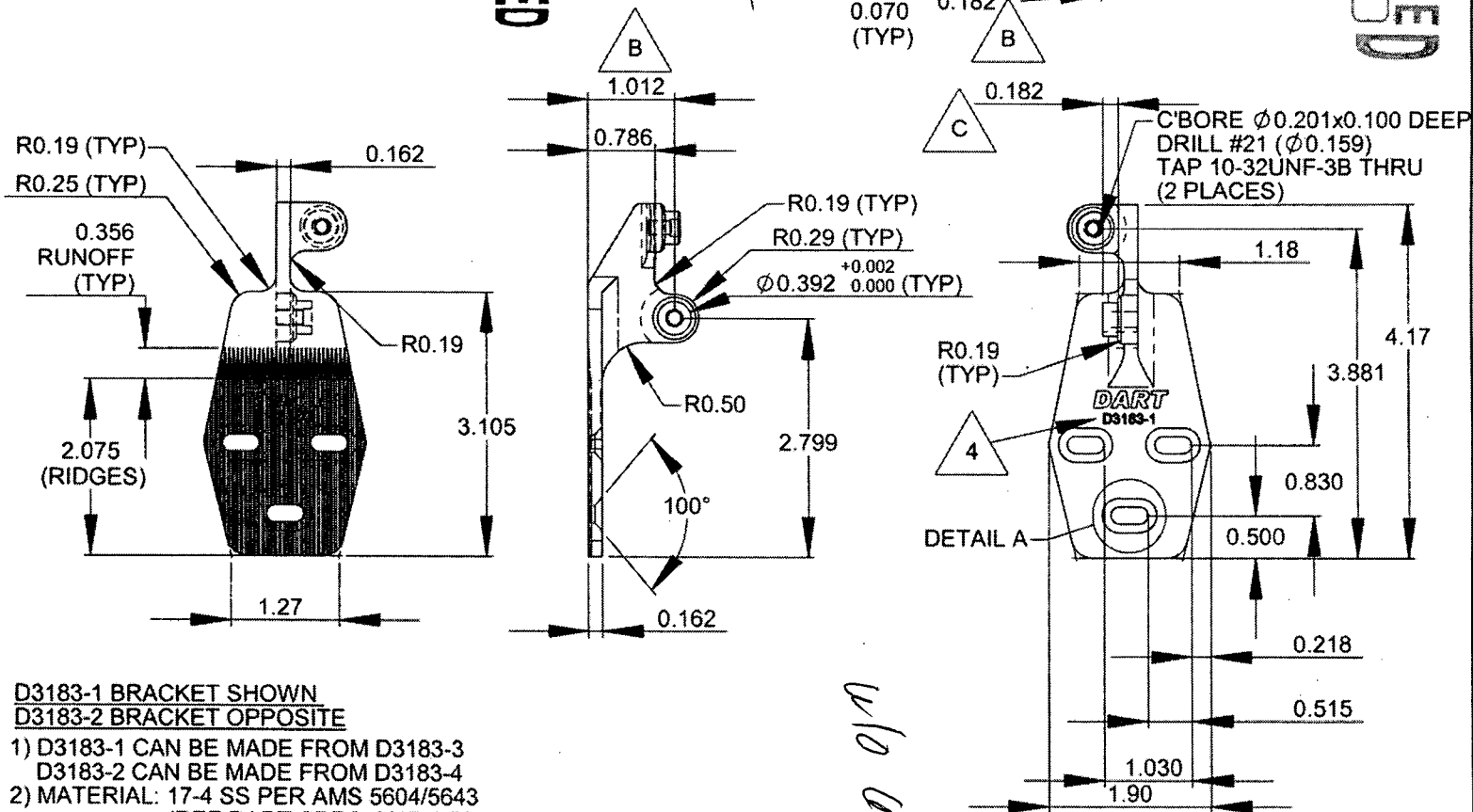
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SHEET 2 OF 4 SCALE 1:2	

**RELEASED**  
04.03.01**DEO ATTACHED**

**D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

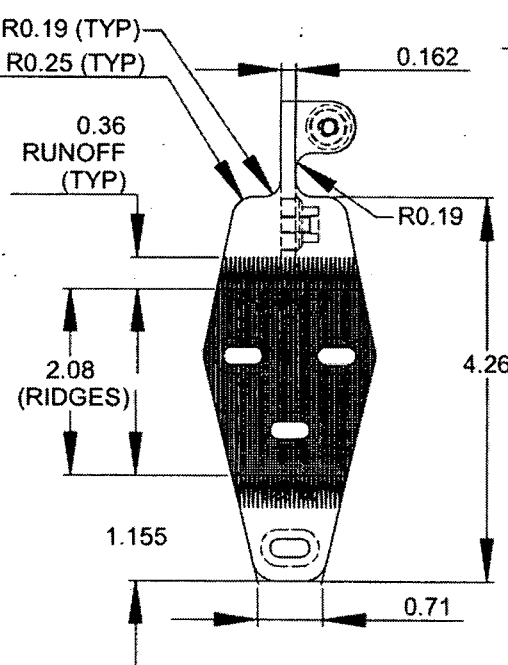
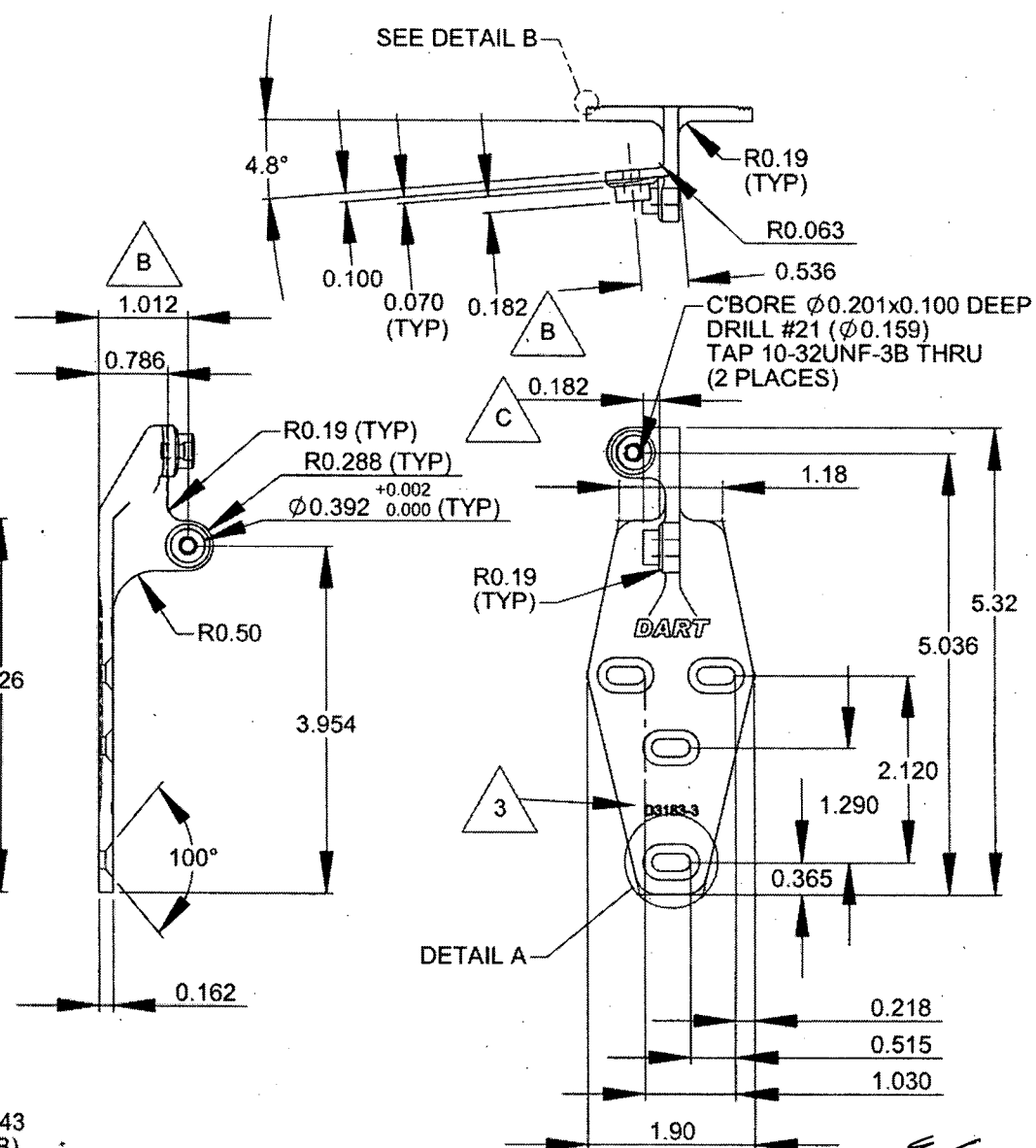
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

QA COPY  
ISSUED

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. C
04.02.17	BRACKET ASSEMBLY	SHEET 3 OF 4
		SCALE 1:2



D3183-3 BRACKET SHOWN  
(REPLACES BELL P/N 412-030-304-105)  
D3183-4 BRACKET OPPOSITE  
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DEO ATTACHED  
RELEASED  
24.02.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

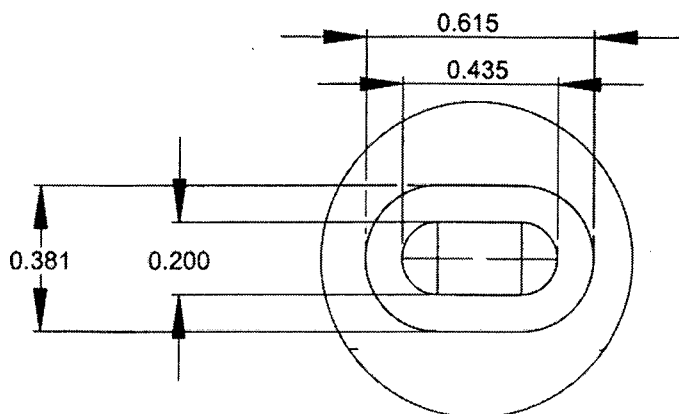
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1

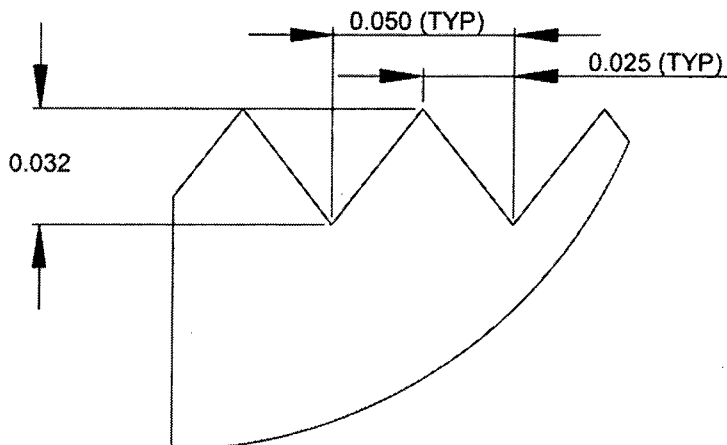


DETAIL A (2 : 1)

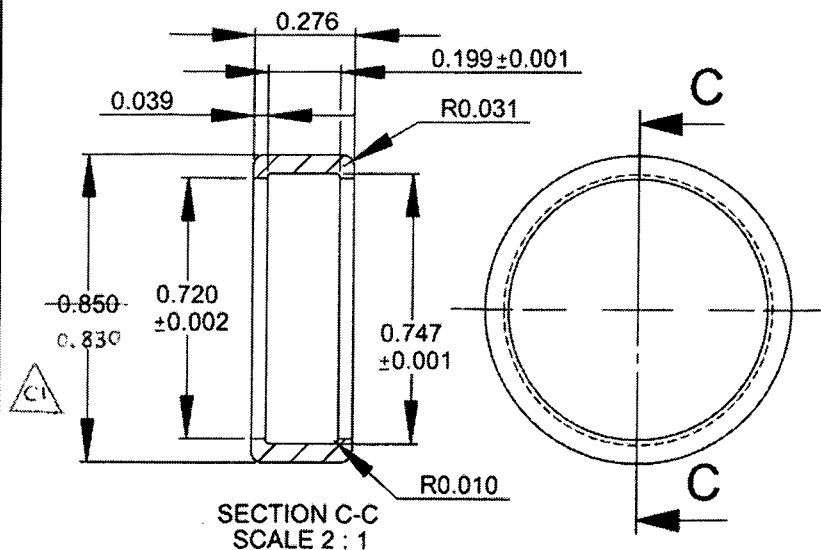
*w/b 6/4/80*

RELEASED  
04.03.01

DEO ATTACHED



DETAIL B (20 : 1)



**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries